

Work Order ID 61915

Thursday, September 09, 2010 1:16:29 PM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Item Name: Skidtube RH

Stop



Start Date: 9/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10-9-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 005.

8/10/10/126

HJ for BG 10-10-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DescriptionSet Up/
Run Hours

Tool ID

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Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

Skidtubes

Skidtubes

0.00

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)
ONLY DRILL ONE SIDE OF FWD SADDLE HOLES USING DT81507- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8- Clecko DT9642 and drill fwd saddle holes on second side, ensure proper positioning.

9- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

10- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to

SAD
10-09-27

JB 10/09/14

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

0.297".

11-Open up holes of Detail A to 0.297" (total of 2 holes per side)

12-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: M114877

13-Grind welds flush as per Dwg D2750

SAD
10-09-27
BE 10/09/10

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/09/27

(70)

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
02/10/03	1							

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

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Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☒ Sikaflex-291 batch: B115114 ☐ ☐
exp. date: 01-2011

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R ☐ Aluminum Rod batch: M115778

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

SAD
10-09-28

BE 10/09/06

BE 10/09/06

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Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00

BR 10-10-13



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

①

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

BR 10-10-13



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:00
OVEN TEMPERATURE: 320°
FINISH TIME: 11:30

①

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

⇒ 10/10/11

1 0

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

✓ Install inserts as per dwg D2750

⇒ M 10/10/14

1 0

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3"
batch: N/A3-Install blade fitting D3488-042, wearshoes and ground handling hardware as
per dwg D2750

SIKA FLEX 241

✓ BATCH: M115114

EXP DATE: 11/01

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: M114189

5-Coat all exposed fasteners with "LPS Procyon"

batch: M114596

⇒ J 10/10/15

1 0

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



0.00 S 10/10/25

QC

Memo

Quality Control

250

Pick Kit

0.00



0.00

Packaging

Memo

Packaging

260

QC4- 100% Inspect kits for completeness

0.00



0.00 S 10/10/26

QC

Memo

Quality Control

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
	Packaging								
	Memo	0.00							
	Package as per PPP D350-636-012								
280	QC21- Final Inspection - Work Order Release	0.00							
	QC	0.00							
	Memo								
	Quality Control								

EO 10/14/22 (C)

10/10/28

MF 10-10-27

1361915

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, September 09, 2010 1:16:33 PM

Page 1

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Parent Item Name: Skidtube RH

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
IPP Rev: J 06-03-29 As per Rev D EC
IPP Rev: K 06-07.13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC
IPP Rev: M 08-04-22 update steps 4,13 DD verified by: EC
IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec IPP Rev: O
10.06.22 revise seq110 DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS4-1032-225		Purchased	No			220	Each	5,329.000	38	38			
Insert													

Location Loc Qty Loc Code

PK011

5329

110768

5329

AN3C5A		Purchased	No			230	Each	1,530.000	34	34			
Bolt													

Location Loc Qty Loc Code

ST350

1520

114330

11

115015

209

115108

300

115316

300

115371

100

115422

100

115594

500

ST351

10

113121

10

10/10/10

V38

10/10/10

X34

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Start Date: 9/9/2010

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Start Qty: 1.00

Required Qty: 1.00

AN3C6A

 BOLT

Purchased No 230 Each 301.0000 4 4



yl 10/10/14

Location Loc Qty Loc Code

ST351 301
 111982 301

AN6C44A

 BOLT

Purchased No 230 Each 125.0000 4 4



yl 10/10/14

Location Loc Qty Loc Code

FG 2
 103964 2
 ST344 123
 111649 2
 114653 1
 114941 75
 115030 45

AN8C35A

 BOLT

Purchased No 230 Each 40.0000 1 1



yl 10/10/14

Location Loc Qty Loc Code

FP 1
 110847 1
 ST346 39
 114442 14
 115188 25

X3
X1

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Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

230 Each 155.0000 38 38



washer



9/10/10

Location

Loc Qty

Loc Code

ST245

155

107534

29

109545

54

111548

72

1115816

x38

AN960C816L Purchased No

230 Each 0.0000 1 1



WASHER NAS1149C08332R / M114915



x1 9/10/10

D2745 Manufactured No

230 Each 165.0000 8 8



Bushing



9/10/10

Location

Loc Qty

Loc Code

ST023

165

52311

5

59112

60

61203

100

x8

D3488-042 Manufactured No

230 Each 12.0000 1 1



Blade Fitting Assembly, RH



9/10/10

Location

Loc Qty

Loc Code

FP008

12

59643

12

x1

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Start Qty: 1.00



Required Qty: 1.00

D3492-041 Manufactured No 230 Each 49.0000 8 8

 Plug Assembly  21 10/10/10



Location	Loc Qty	Loc Code
FP013	49	B61983
59114	1	
61311	48	

D3492-043 Manufactured No 230 Each 75.0000 8 8

 Plug Assembly  21 10/10/10

Location	Loc Qty	Loc Code
FP	2	B61842
54682	2	
FP013	73	
59117	1	
59190	4	
61207	8	
61503	60	

D3535-25 Manufactured No 230 Each 9.0000 1 1

 Wearshoe  21 10/10/10

Location	Loc Qty	Loc Code
FP18	9	B62033
59623	9	

D3536-25 Manufactured No 230 Each 36.0000 1 1

 Gasket  21 10/10/10

Location	Loc Qty	Loc Code
FP12	36	
59625	10	
61707	26	

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Shop Packet Print

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Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

21.0000

3

3



Wearpad



10/10/14

Location

Loc Qty

Loc Code

FP

1

B61986

X3

55465

1

FP17

6

57713

3

60491

3

FP18

14

61201

14

D3631-1

Manufactured No

230

Each

467.0000

8

8



Washer



10/10/14

Location

Loc Qty

Loc Code

ST072

193

60755

193

X8

ST076

274

52693

206

54388

68

D3672-1

Manufactured No

230

Each

901.0000

4

4



Phenolic Washer



10/10/14

Location

Loc Qty

Loc Code

ST077

901

42329

150

52505

751

X4

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 09, 2010 1:16:33 PM

Page 6

Work Order ID: 61915



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

7.0000

1

1



Wearplate



Handwritten: 10/10/14

Location

Loc Qty

Loc Code

FP17

7

B61702

Handwritten: X1

58573

7

D3793-1

Manufactured No

230

Each

14.0000

1

1



Wearshoe



Handwritten: 10/10/14

Location

Loc Qty

Loc Code

FP18

14

59151

1

59630

1

61244

12

Handwritten: X1

D3793-3

Manufactured No

230

Each

13.0000

1

1



Wearshoe



Handwritten: 10/10/14

Location

Loc Qty

Loc Code

FP18

12

61258

12

Handwritten: X1

FP19

1

57947

1

D3794-1

Manufactured No

230

Each

32.0000

1

1



Gasket



Handwritten: 10/10/14

Location

Loc Qty

Loc Code

FP010

32

57942

6

61704

26

Handwritten: X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 09, 2010 1:16:33 PM

Work Order ID: 61915

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

37.0000

1

1



Gasket



10/10/11

Location

Loc Qty

Loc Code

FP10

27

60826

1

61712

26

FP18

10

56066

9

59153

1

MS21043-6

Purchased

No

230

Each

674.0000

4

4



NUT



10/10/11

Location

Loc Qty

Loc Code

ST301

674

112314

674

MS21083C8

Purchased

No

230

Each

69.0000

1

1



NUT



10/10/11

Location

Loc Qty

Loc Code

ST303

69

113845

5

114934

14

115594

50

X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 09, 2010 1:16:33 PM

Work Order ID: 61915

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

*

Purchased

No

230

Each

309.0000

8

8



O-RING



10/10/14 PTO=>

Location

Loc Qty

Loc Code

FP

309

110715

100

110915

159

115589

50

NAS1611-013

Purchased

No

230

Each

232.0000

8

8



O-RING



10/10/14

Location

Loc Qty

Loc Code

FP

232

114451

32

115460

100

115589

100

AN8C21A



BOLT

Purchased

No

250

Each

33.0000

2

2



10/10/25 sl

Location

Loc Qty

Loc Code

ST345

33

113558

1

114653

32

AN960C816L



WASHER

Purchased

No

250

Each

0.0000

1

2



10/10/25 sl

NAS149C0832A

W/O: 61915		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/10/14	230	Replace NAS 1611-010 "O" Rings For D 25921-3/M 61792 "O" Rings	JH	10/10/14	48		10/10/14

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 09, 2010 1:16:33 PM

Page 9

Work Order ID: 61915

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D2741
Blade, 350 Skidtube

Manufactured No 250 Each 45.0000

1
10/16/25 SP

Location Loc Qty Loc Code

ST466 45
57949 7
60210 38

D3493-1
Washer

Manufactured No 250 Each 24.0000

2
10/10/25 SP

Location Loc Qty Loc Code

ST065 24
60873 24

D3532-1
Spacer

Manufactured No 250 Each 9.0000

2
B61673 10/10/25 SP

Location Loc Qty Loc Code

ST068 9
60510 9

D3672-13
Phenolic Washer

Purchased No 250 Each 818.0000

2
10/10/25 SP

Location Loc Qty Loc Code

ST077 818
54363 818

Thursday, September 09, 2010 1:16:33 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 09, 2010 1:16:33 PM

Work Order ID: 61915

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

69.0000

1

2



NUT



10/10/258

Location

Loc Qty

Loc Code

ST303

69

113845

5

114934

14

115594

50

D2600-3-BENT

Manufactured

No

110

Each

16.0000

1

1



Extrusion Bent



Location

Loc Qty

Loc Code

LG

16

59410

1

61633

5

61634

10

D2744

Manufactured

No

110

Each

18.0000

1

1



Cap



10-9-24

Location

Loc Qty

Loc Code

LG

18

59198

18

D2739

Manufactured

No

160

Each

5.0000

1

1



350 I Beam



BE 10/09/16
SAD 10-09-28

Location

Loc Qty

Loc Code

LG

5

61637

5

B61998

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 11

Thursday, September 09, 2010 1:16:33 PM

Work Order ID: 61915



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160 Each

203.0000 8 8



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

203

50281

10

57953

2

59111

191

8

BE 10/09/30

D3490-3

Manufactured No

160 Each

43.0000 4 4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

43

60294

6

61218

37

B 62451 x3

BE 10/09/30

A

1

BE 10/09/30

D3490-1

Manufactured No

160 Each

81.0000 4 4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

81

59424

3

61217

78

4

BE 10/09/30

Thursday, September 09, 2010 1:16:33 PM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

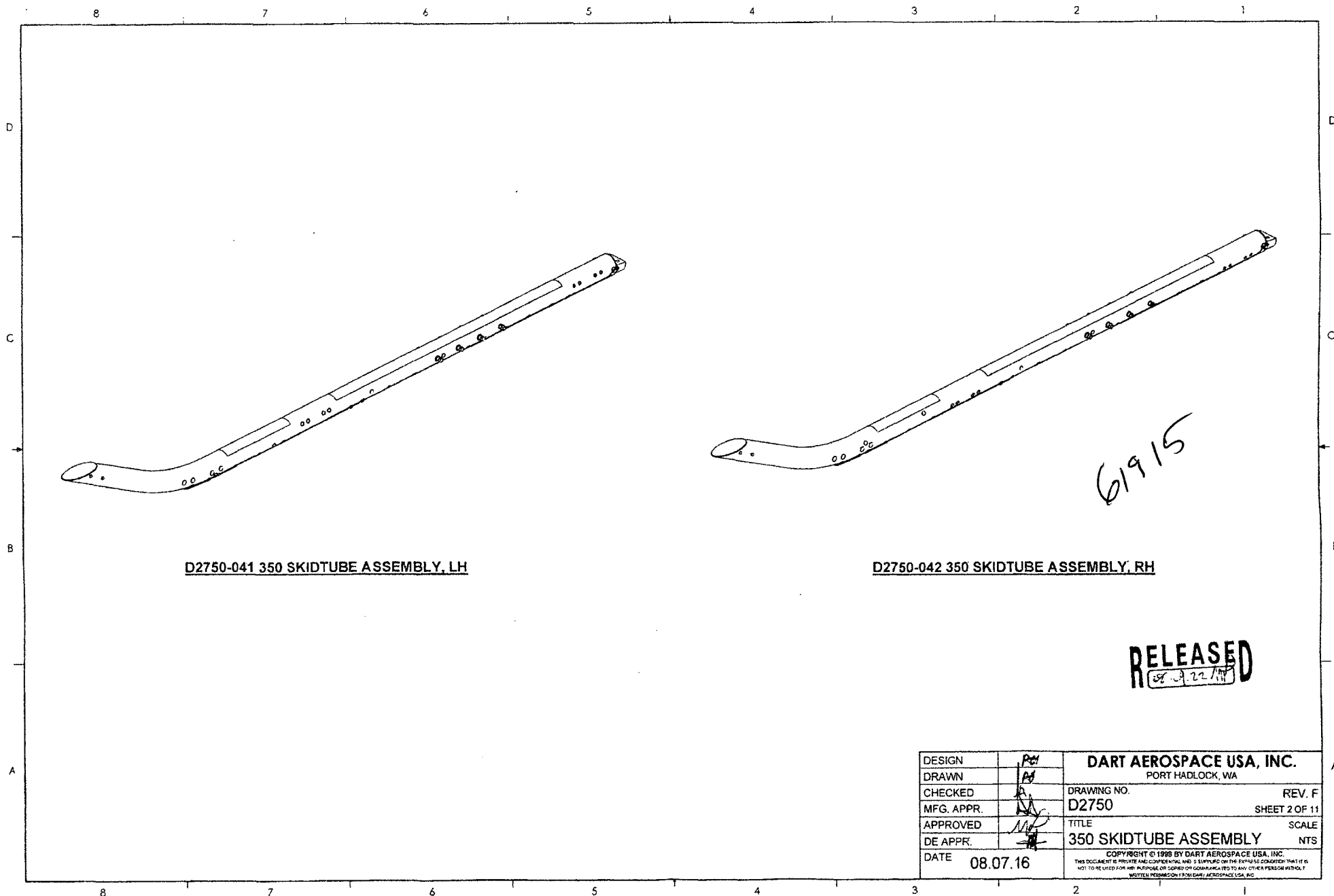
QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 28.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL Δ
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL Δ

61915
RELEASED
65-127-1-14

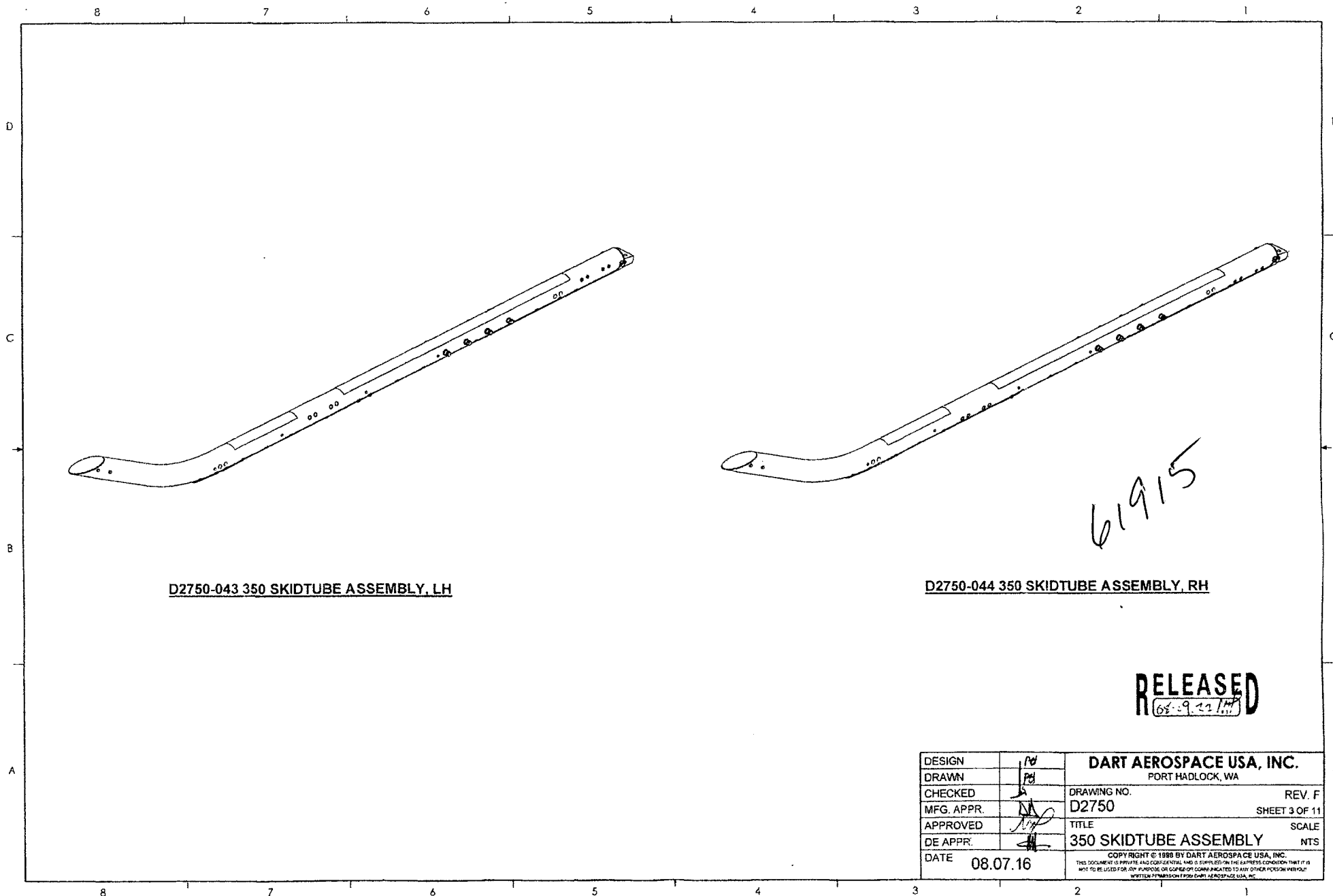
F	INCORPORATE DSI 8413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (6 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H6L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DED 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	96.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	96.09.01
A	NEW ISSUE	DS	96.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	RA	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

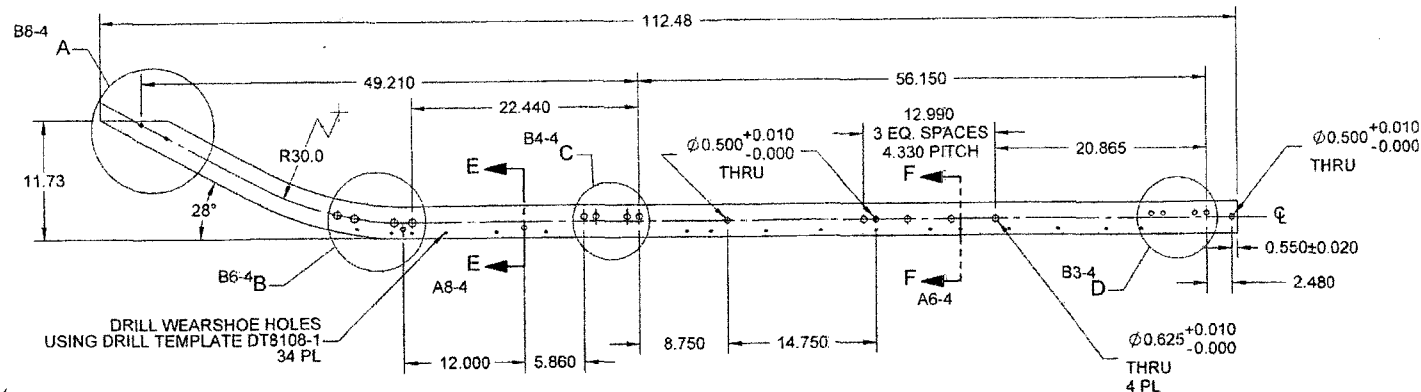


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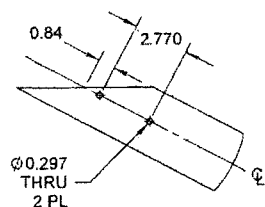
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88-3-22-14

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CHECKED	AM	DRAWING NO. D2750	REV. F
MFG. APPR.	AM	SHEET 2 OF 11	
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



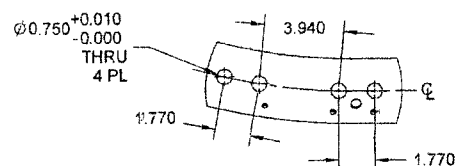


D2750-1 LH SKIDTUBE



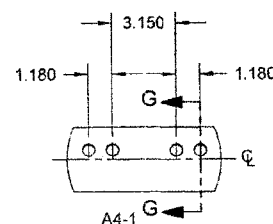
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D7-4



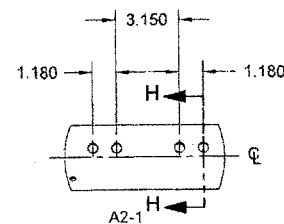
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D7-4



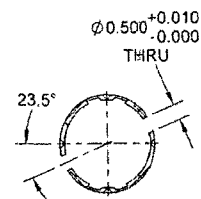
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SCALE 2X

D5-4



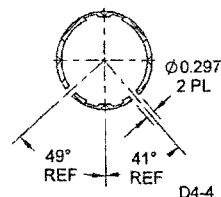
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D3-4



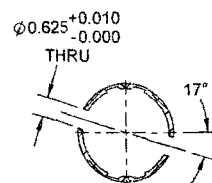
SECTION E-E
SCALE 3X, 2 PL

D6-4



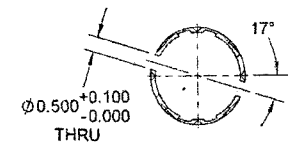
SECTION F-F
SCALE 3X, 17 PL

D4-4



SECTION G-G
SCALE 3X, 4 PL

B4-4



SECTION H-H
SCALE 3X, 4 PL

B2-4

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DRAWN	IPB
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.07.16

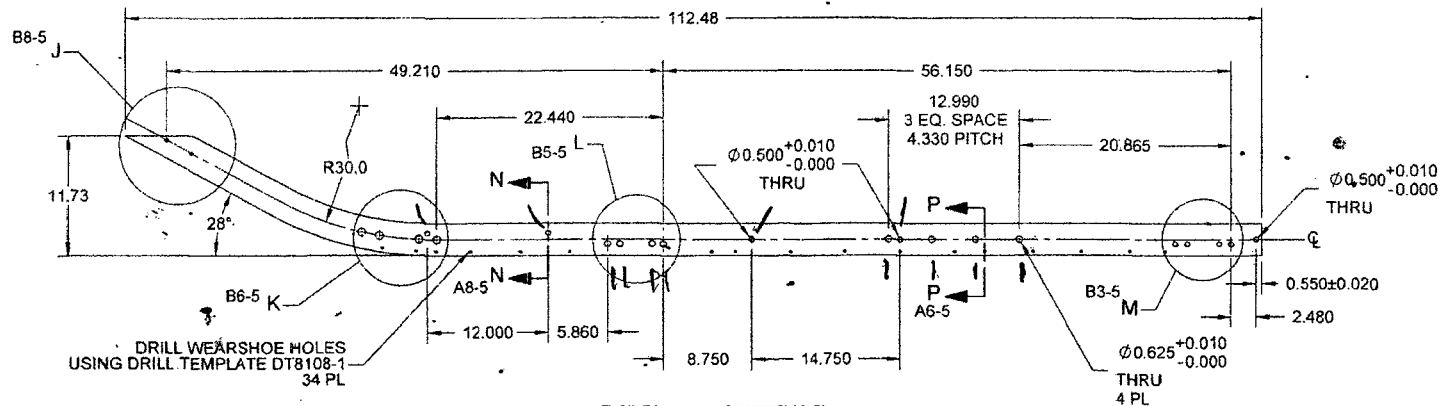
DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D2750** REV. F
SHEET 4 OF 11
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

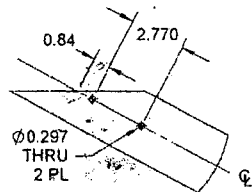
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61915

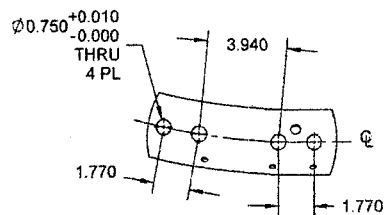
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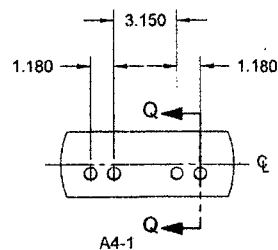
D2750-2 RH SKIDTUBE



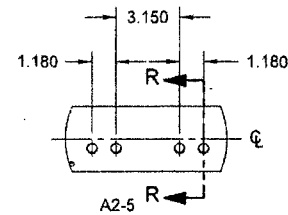
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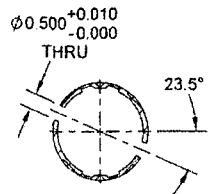
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SCALE 2X



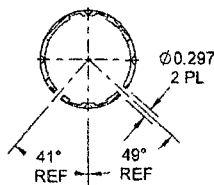
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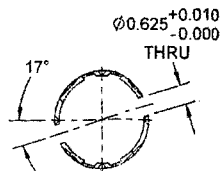
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SCALE 2X



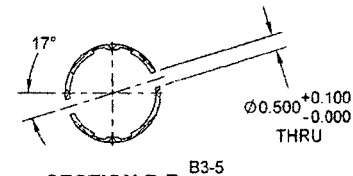
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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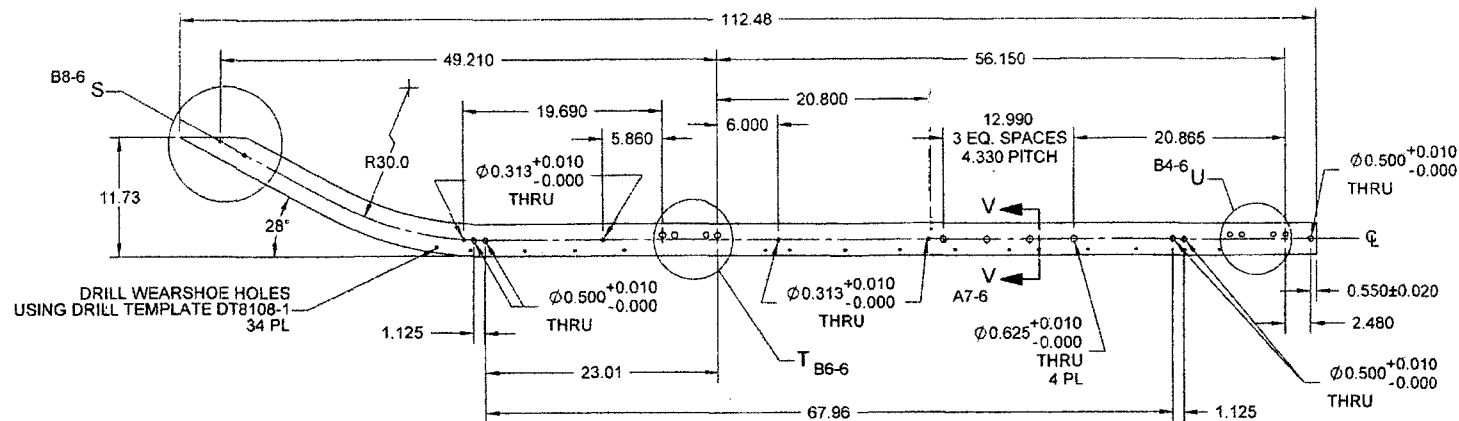
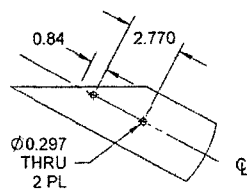
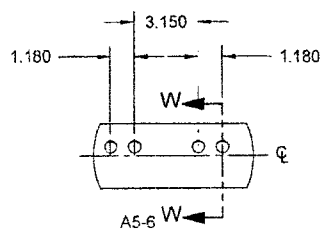
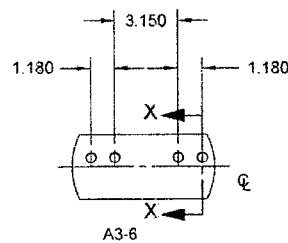
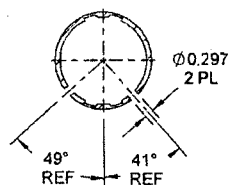
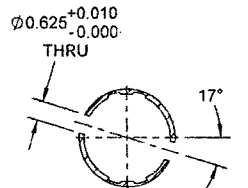
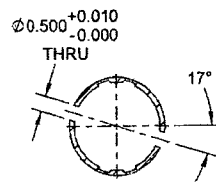
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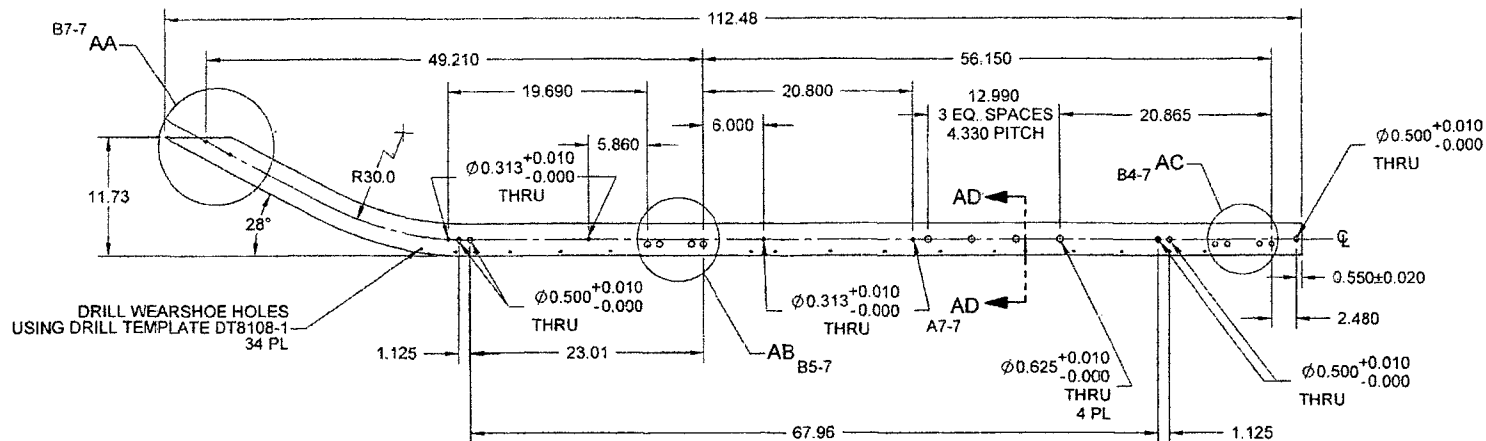
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**D2750-3 LH SKIDTUBE****DETAIL S**
SCALE 2X**DETAIL T**
SCALE 2X**DETAIL U**
SCALE 2X**SECTION V-V**
SCALE 3X, 17 PL**SECTION W-W**
SCALE 3X, 4 PL**SECTION X-X**
SCALE 3X, 4 PL

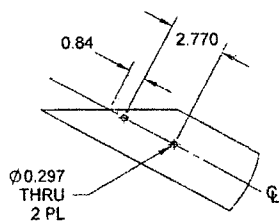
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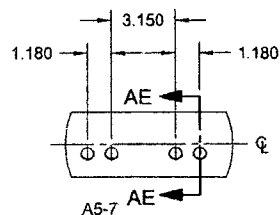
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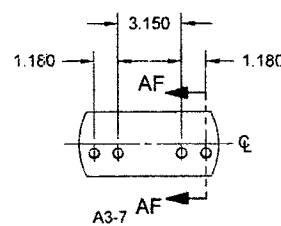
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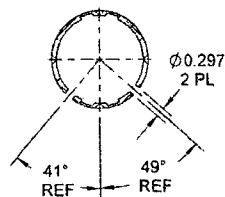
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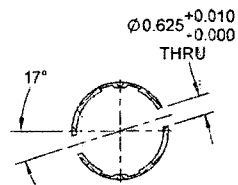
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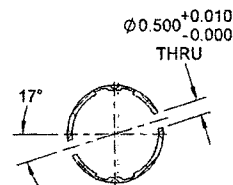
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SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
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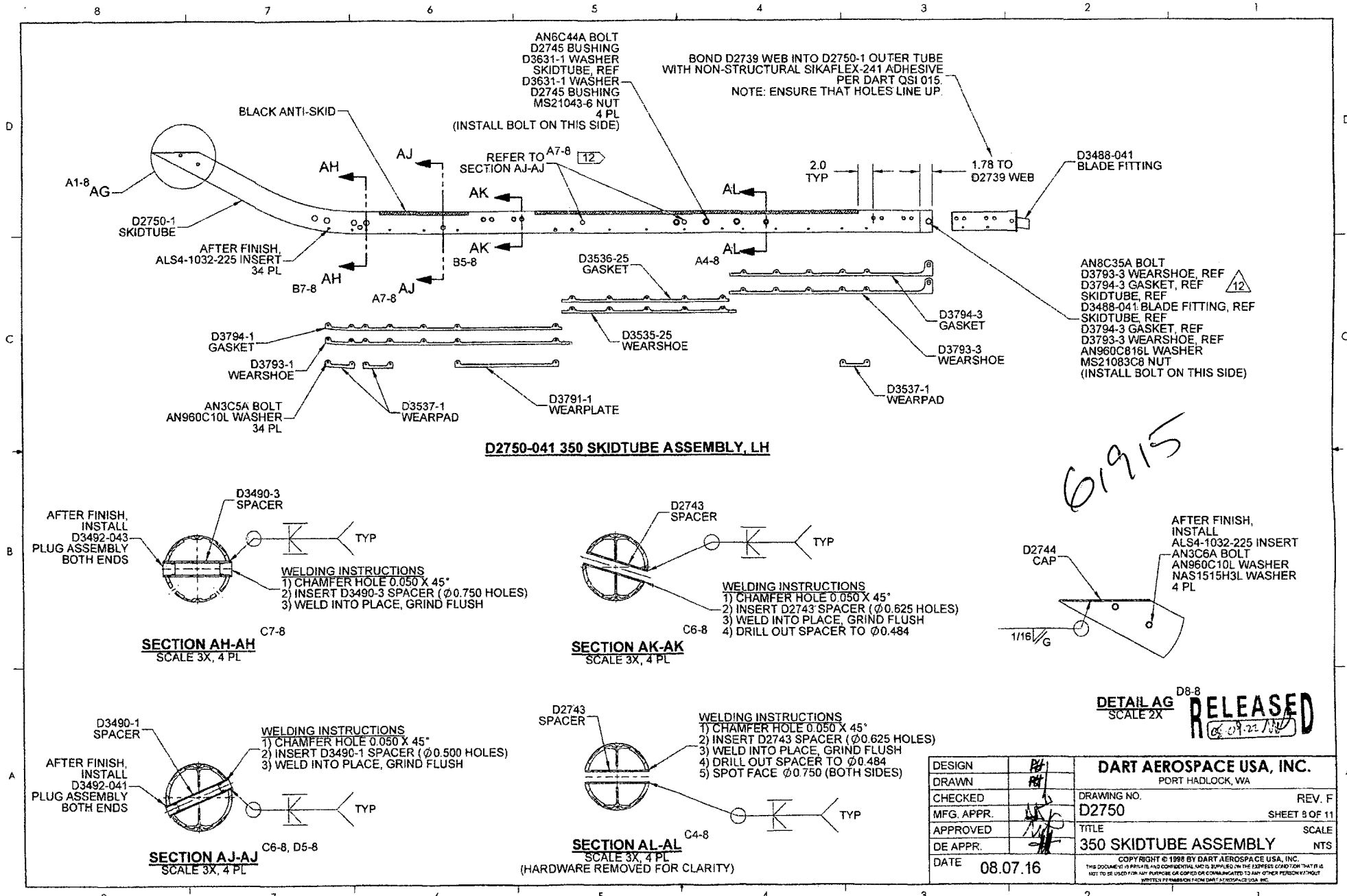


SECTION AF-AF
SCALE 3X, 4 PL

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D2750-041 350 SKIDTUBE ASSEMBLY, LH

61915

SECTION AH-AH
SCALE 3X, 4 PL

SECTION AK-AK
SCALE 3X, 4 PL

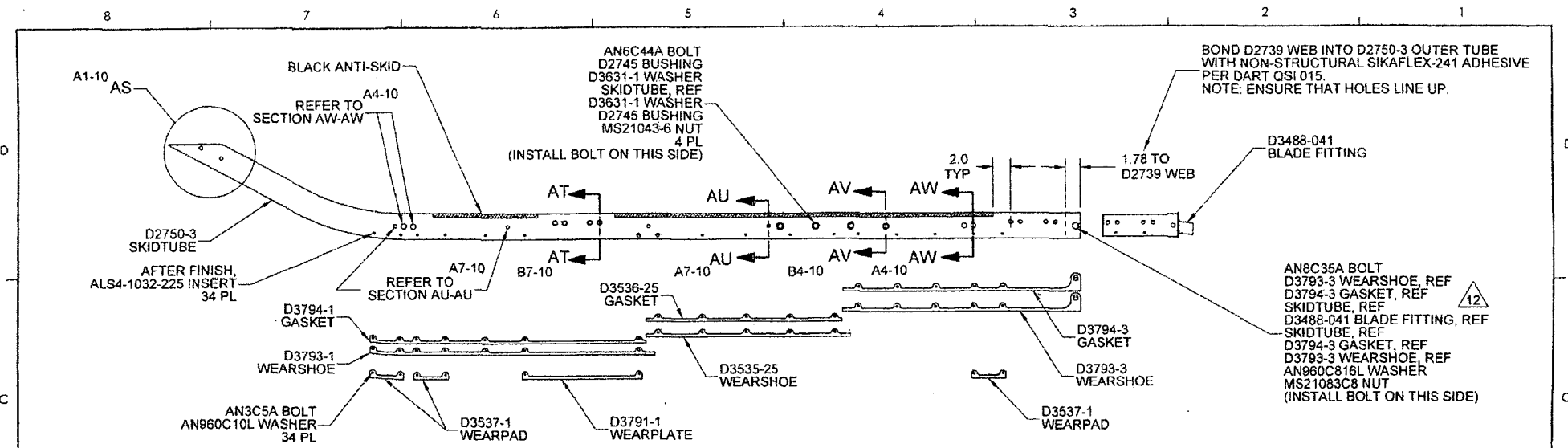
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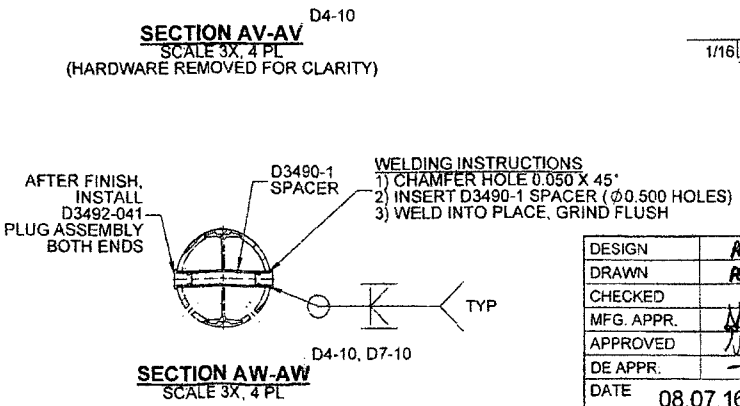
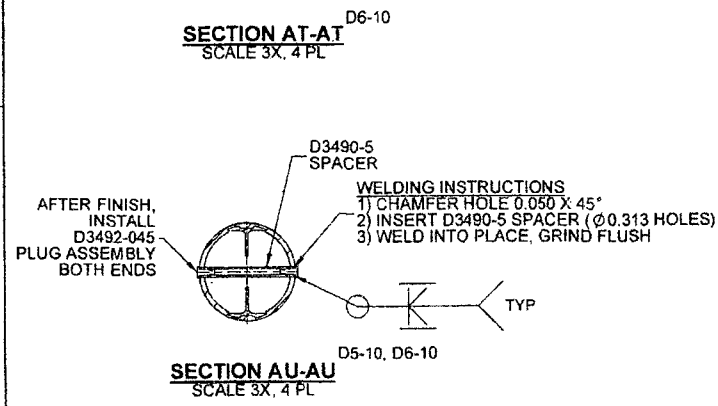
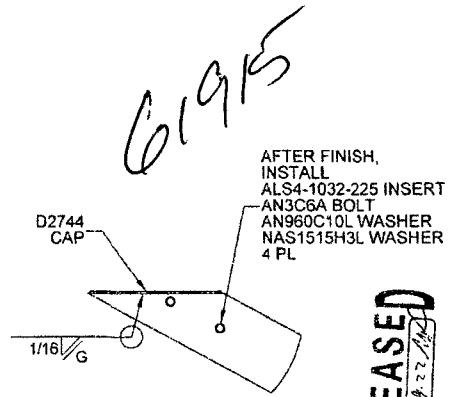
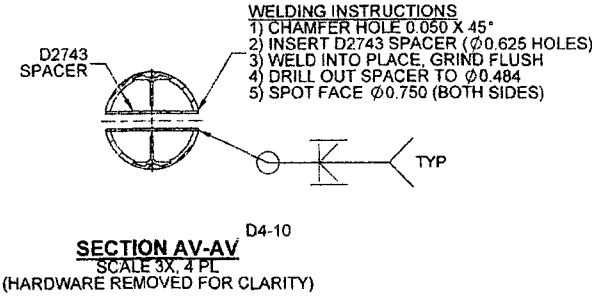
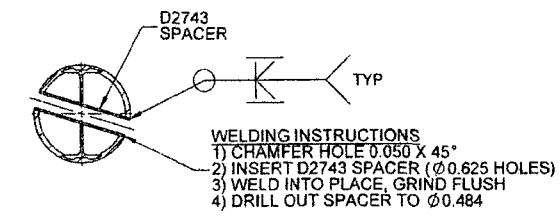
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DETAIL AG
SCALE 2X
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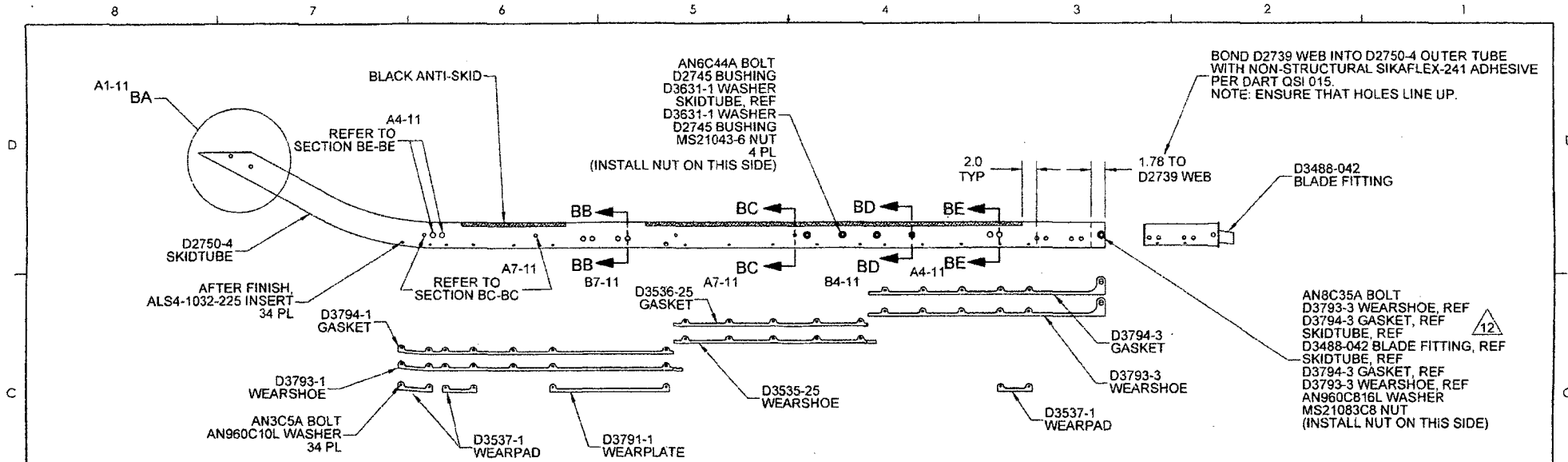


D2750-043 350 SKIDTUBE ASSEMBLY, LH

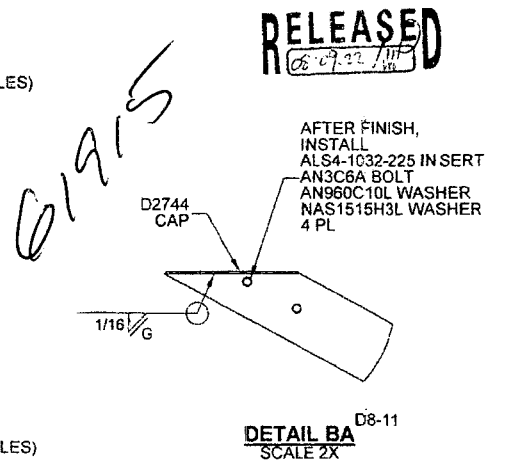
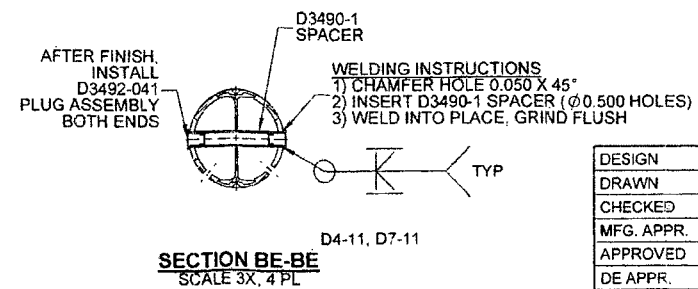
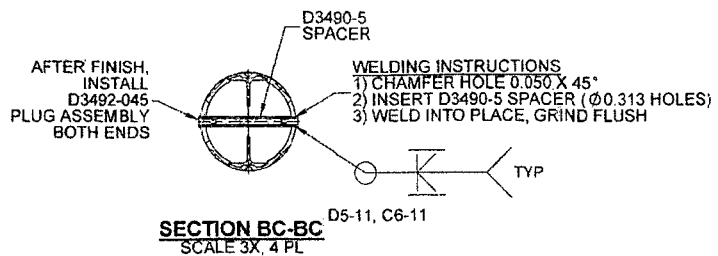
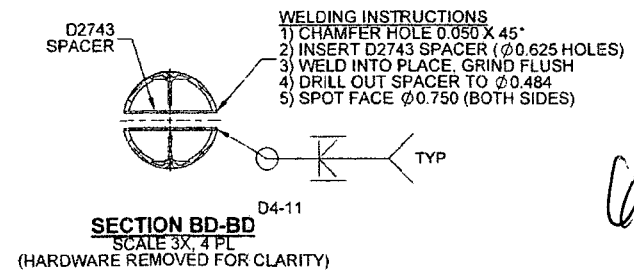
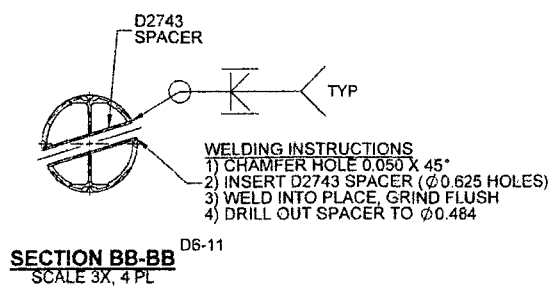


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D2750-044 350 SKIDTUBE ASSEMBLY, RH



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01915

NO. 236

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 60988
Part number: D350-636-012
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 10.08.12

Welder [Signature] Date of Test Coupon 10.08.12

The above named individual is qualified in accordance with AWS D17.1.2001 to weld